

# Work Order ID 120087

June-18-14 1:24:51 PM

*ASD*  
**\*120087\***

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Item ID: D2724-041 **D2724-041**  
 Revision ID: **B120087**  
 Item Name: 206L Step Assembly **REV-C**  
 Start Date: 6/04/14 Start Qty: 5.00 **\*5\***  
 Required Date: 6/04/14 Req'd Qty: 5.00 **\*5\***  
 Reference: **\*N900040100\***  
 Accept **\*NS1\***  
 Setup Start **\*NS2\***  
 Stop  
 Cust Item ID:  
 Customer:

Approvals: Process Plan: *W* Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2724	Rev C								
100	Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	Cut D2724-1 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding								<i>DMC</i> <i>14-6-20</i>
110	Large Fab	0.00							
<b>*110*</b>									
Large Fab	Memo	0.00							
Large Fab	Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig DT (One End Only) A/R AL ROD Batch: <i>125091</i> Grind end cap welds flush <i>128385</i>								<i>DMC</i> <i>14-07-23 14-07-22</i>

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Item ID: D2724-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206L Step Assembly  
 Start Date: 6/04/14 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 5.00 **\*5\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				5*		147.23	DAS 24 9-89
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				5*		147.23	DAS 24 9-89
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				5x		14-07-29	DMC





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Item ID: D2724-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: 206L Step Assembly  
 Start Date: 6/04/14 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 5.00 \*5\* Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210	QC3- Inspect Part Finish	0.00							
*210*									
QC	Memo	0.00				56A	f	ll	107/30
Quality Control									

68-6  
91  
DAS

220	Wing Walk as per dwg QSI005 4.4 Batch <u>11266900</u>	0.00							
*220*									
HandFinish	Memo	0.00				56A	f	ll	107/30
Hand Finishing									

230	QC3- Inspect Part Finish	0.00							
*230*									
QC	Memo	0.00							
Quality Control									

DAS  
16  
9-89

14/7/31

15  
LH

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Item ID: D2724-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: 206L Step Assembly  
 Start Date: 6/04/14 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 5.00 \*5\* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location:	0.00							
*240*									
Packaging	Memo								
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
*250*									
QC	Memo								
Quality Control									

5x 14-07-31

14/8/14

14-8-1



# Picklist Print

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Work Order ID: 120087

**\*120087\***

Parent Item: D2724-041

**\*D2724-041\***

Parent Item Name: 206L Step Assembly

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

91.0000

1

5

**\*D2622-120C\***

Step Extrusion

**\*\***

DMC  
14-6-20

Location

Loc Qty

Loc Code

HALL

32

109575

32

WA003

59

101765

1

115141

58

5

D2734

Manufactured

No

110

Each

123.0000

1

5

**\*D2734\***

Step End Plate

**\*\***

CPL 14-7-28

Location

Loc Qty

Loc Code

WA003

123

119286

86

119498

36

99709

1

5

D2734

Manufactured

No

160

Each

123.0000

1

5

**\*D2734\***

Step End Plate

**\*\***

CPL 14-7-25

Location

Loc Qty

Loc Code

WA003

123

119286

86

119498

36

99709

1

5



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Work Order ID: 120087

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Parent Item: D2724-041

\*D2724-041\*

Parent Item Name: 206L Step Assembly

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 5.00

Required Qty: 5.00

D3458-1

Manufactured No

110

Each

19.0000

2

10

\*D3458-1\*

Step Mounting Plate

\*\*

14.07.21

Location

Loc Qty

Loc Code

WA003

120233

19

119278

18

96904

1

D3458-3

Manufactured No

110

Each

21.0000

2

10

\*D3458-3\*

Step Mounting Plate

\*\*

14.07.21

Location

Loc Qty

Loc Code

WA003

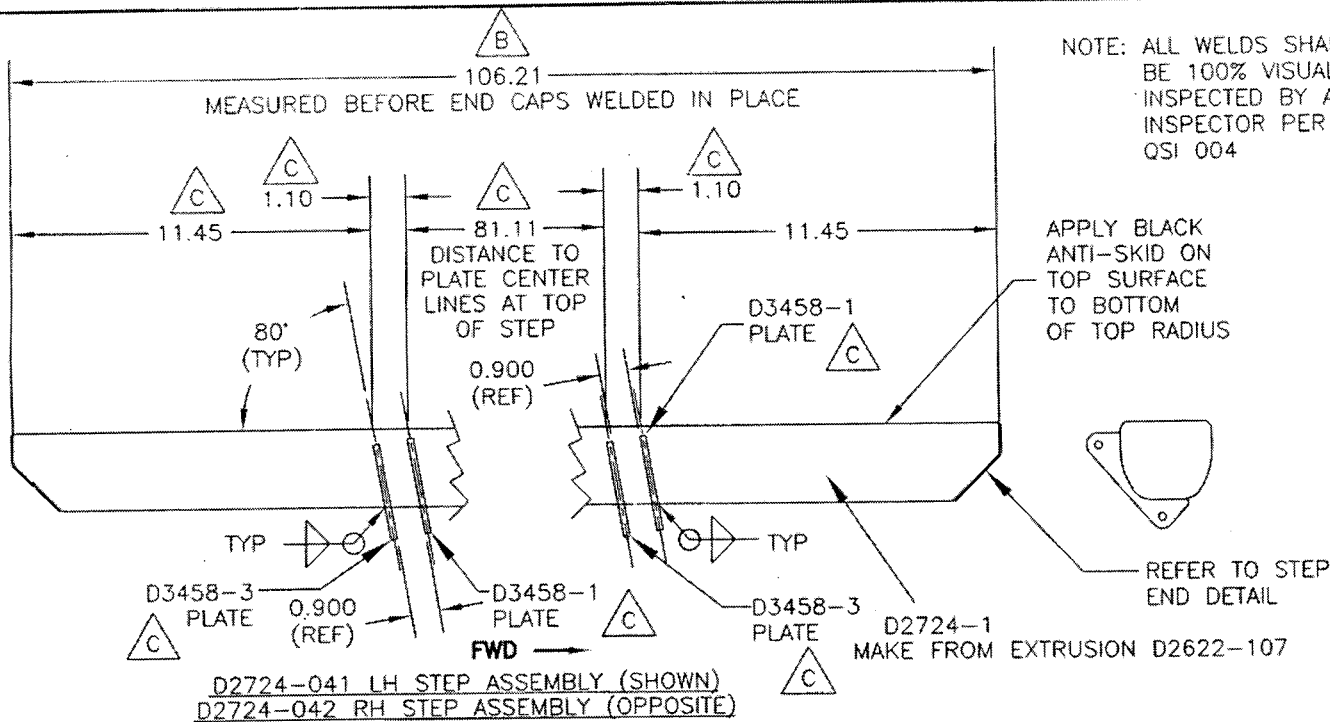
122212

21

119279

21

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APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

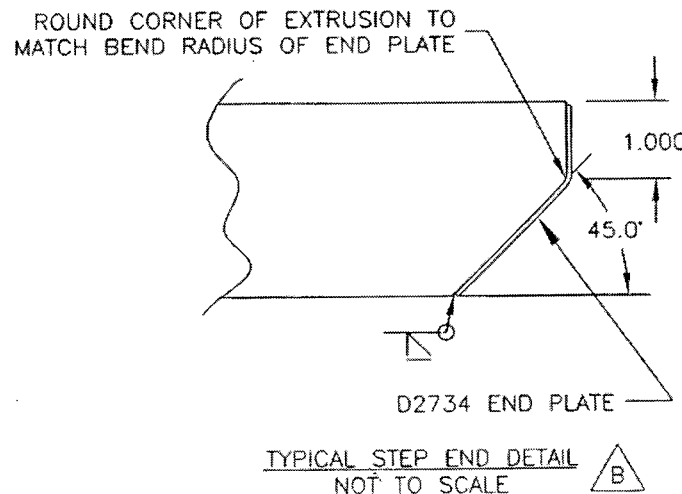
D2724-1  
MAKE FROM EXTRUSION D2622-107

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED  
8.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	<del>PH</del>	APPROVED	<del>PH</del>	DRAWING NO.	REV. C
DATE	05.09.19			D2724	SHEET 1 OF 1
				TITLE	SCALE
				206L/407 STEP ASSEMBLY	NTS
A		97.12.04		NEW ISSUE	
B		98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES	
C		05.09.19		RE-DESIGN, ADD D3458-1/-3	

# DART

120087  
MLS  
14-06-05